

Amendments to the Claims:

This listing of the claims replaces all such prior listings.

Listing of Claims:

1. (Previously presented) A method comprising:

placing a plurality of prewritten discs, each prewritten disc having servo tracks

characterized by a concentricity offset in a direction of an alignment axis that is in the same angular direction for all of the plurality of prewritten discs in relation to a center of the respective prewritten disc, around a motor hub, the prewritten discs placed around the motor hub with respect to each other so that the alignment axes among the plurality of prewritten discs are angularly disposed symmetrically around the motor hub; and

after the placing step, biasing each of the plurality of prewritten discs in a direction of the respective alignment axis to concentrically align the servo tracks of a first disc of the plurality of prewritten discs with the servo tracks of a second disc of the plurality of prewritten discs.

2. (Canceled)

3. (Previously presented) The method of claim 1 wherein the biasing step comprises pressingly engaging against an edge of each of the prewritten discs.

4. (Canceled)

5. (Previously presented) The method of claim 1 wherein the placing step is characterized by at least two of the symmetrically placed alignment axes being non-collinear.

6. (Previously presented) The method of claim 1 wherein the placing step is characterized by at least two of the symmetrically placed alignment axes being collinear.

7. (Previously presented) The method of claim 1 wherein the placing step is characterized by detecting an indicia on each of the prewritten discs associated with the respective alignment axis.

8. (Previously presented) The method of claim 7 wherein the placing step is characterized by the indicia comprising a laser index mark.

9. (Previously presented) The method of claim 7 wherein the placing step is characterized by a first indicia on one side of each prewritten disc associated with the respective alignment axis and a second indicia different than the first indicia on the other side of each prewritten disc associated with the respective alignment axis.

10. (Withdrawn) A disc stack comprising a disc biased against a motor hub in relation to a reference axis adapted for angularly orienting the disc for writing servo pattern information to the disc before the disc is biased against the motor hub.

11. (Withdrawn) The disc stack of claim 10 wherein the reference axis is radially disposed in relation to the disc.

12. (Withdrawn) The disc stack of claim 10 comprising a second disc biased against the motor hub in relation to a second reference axis adapted for angularly orienting the second disc for writing servo pattern information to the second disc before the second disc is biased against the motor hub.

13. (Withdrawn) The disc stack of claim 12 wherein the first reference axis and the second reference axis are substantially parallel.

14. (Withdrawn) The disc stack of claim 10 wherein the reference axis comprises an indicia.

15. (Withdrawn) The disc stack of claim 10 wherein the reference axis comprises a laser index mark.

16. (Withdrawn) The disc stack of claim 10 wherein the angular reference comprises a first indicia on one side of the disc and a second indicia on the other side of the disc.

17. (Withdrawn) The disc stack of claim 16 wherein first indicia is different than the second indicia.

18. (Withdrawn) A data storage device comprising a disc stack constructed by steps for biasing comprising:

placing a disc comprising servo pattern information written in relation to an angular reference axis around a motor hub; and
biasing the disc against the motor hub in relation to the angular reference axis.

19. (Withdrawn) The data storage device of claim 18 wherein the steps for biasing comprises:

obtaining a second disc comprising servo pattern information written in relation to a second angular reference axis;
placing the second disc around the motor hub; and
biasing the second disc against the motor hub in relation to the second angular reference axis.

20. (Withdrawn) The data storage device of claim 19 wherein the steps for biasing is characterized by biasing the first disc and second disc in different directions.

21. (Previously presented) The method of claim 9 wherein the placing step is characterized by the first indicia comprising a first line that is collinear with the alignment axis and a second line angularly disposed from the first line.

22. (Previously presented) The method of claim 21 wherein the placing step is characterized by first and second indicia with each comprising a third line angularly disposed from the first line.

23. (Previously presented) The method of claim 22 wherein the placing step is characterized by first and second indicia with each comprising second and third lines that are nonsymmetrically disposed from the first line.

24. (Previously presented) The method of claim 23 wherein the placing step is characterized by first and second indicia that are mirror images of each other.

25. (Withdrawn) A disc stack comprising first and second discs that are each prewritten before stacking them with servo tracks that are offset with respect to a disc center and in relation to an angular reference axis, the discs being placeable with respect to each other around a hub and subsequently fixable in rotation with the hub, wherein placing the discs to align the angular reference axes and biasing the discs against the hub in a direction of the angular reference axes places the first disc concentrically disposed to the second disc and the servo tracks of the first disc concentrically disposed to the servo tracks of the second disc, and wherein placing the discs to misalign the angular reference axes and biasing each disc against the hub in a direction of the respective angular reference axis places the first disc nonconcentrically disposed to the second disc and the servo tracks of the first disc concentrically disposed to the servo tracks of the second disc.

26. (Withdrawn) The disc stack of claim 25 wherein at least one of the discs comprises an alignment mark incident with the angular reference axis.

27. (Withdrawn) The disc stack of claim 26 wherein the disc comprises a first alignment mark on one side of the disc incident with the angular reference axis and a second alignment mark on an opposing side of the disc incident with the angular reference axis.

28. (Withdrawn) The disc stack of claim 27 wherein the first and second alignment marks are different.

29. (Withdrawn) The disc stack of claim 28 wherein the first and second alignment marks are mirror images of each other.

30. (Withdrawn) A data storage device comprising:

a motor adapted for moving discs in a data reading and writing relationship with respective heads; and

a disc stack formed by steps for stacking two or more of the discs, having prewritten servo information thereon, onto the motor.

31. (Withdrawn) The data storage device of claim 30 wherein the steps for stacking are characterized by writing the servo information to the discs in relation to a common angular reference.

32. (Withdrawn) The data storage device of claim 31 wherein the steps for stacking are characterized by placing discs with prewritten servo information around the motor with the plurality of angular references of each disc symmetrically distributed around the motor.

33. (Withdrawn) The data storage device of claim 32 wherein the steps for stacking are characterized by biasing the discs in a direction of the respective angular references of each disc.